



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-312BL
Job Sheet 166628



Part No: D206-642-312BL

Job Qty: 1 ea

Part Name: Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/12/17

Job Tracking No:

Due Date: 10/27/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Air Evac Lifeteam (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O (*AEL*), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: DWG REV Q SHEETS 29-30 IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev:M 09-03-02 as per DSI9440 rev.a verified by:EC IPP Rev:N 09-03-03 as per DSI9421 rev.b verified by:EC IPP Rev:O as per REV.N DD 10.04.19 verified by:EC IPP Rev:P 14.04.25 ECN14-520 DD verf:JLM IPP REV:Q 15.10.09 ADDED BL DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/27/17	10/27/17	0.00	0.00	Start Up Stores/Pkg1	50	
100	DC	1 pcs	10/27/17	10/27/17	0.00	0.00	DC	17-11-30/17	
110	Packaging	1 pcs	10/27/17	10/27/17	0.00	0.00	Packaging1		
120	QC	1 pcs	10/27/17	10/27/17	0.00	0.00	QC4		
130	Packaging	1 pcs	10/27/17	10/27/17	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea	10/27/17	10/27/17	0.00	0.00	QC21	21 NOV 06 2017	

Part Op 100 - Photocopy bluefile and create labels per PPP D206-642-312 CHG008

Descriptions: 130 - Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3-41A 5003523	8	48	0	0
	AN4-6A 5003521	12	579	0	0
	AN4C5A 5003514	1	30	0	0
	AN5-10A 5003572	4	169	0	0
	AN5-11A 5004448	8	454	0	0
	AN5-12A 5005032	4	500	0	0
	D206-642-341BL 5004200	1	2	0	0
	D206-648-013BL 5003783	1	3	0	0
	D2652	16	120	0	0
	D2712 5003508	10	113	0	0
	D2932-2BL	1	1	0	0
	D2933-2BL	1	3	0	0
	D2934 5003504	2	29	0	0
	D2935 5003503	2	20	0	0
	D2938-2BL	1	1	0	0
	D2939-2BL 5	1	1	0	0
	D3407-043 5003501	1	30	0	0
	D3413-1BL 5004447	1	2	0	0
	D3456-1 5003499	1	18	0	0



S005825



Skidtube RH, Low & High Gear with Standard Wearplates (Ael
Blue)

PART NO:
Revision:
Operation:
Quantity:
Change No:

D206-642-312BL

Start up Operation
1

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 11/03/17
Job No: 166628

D3457-1	5003497	2	16	0	0
MS21042L3	5002282	8	1,117	0	0
MS21042L4	500	12	732	0	0
MS21043-4	5002279	1	975	0	0
NAS1149C0463R	5002888	1	131	0	0
NAS1149D0363J	5002277	8	612	0	0
NAS1149D0463J	5002276	24	1,543	0	0
NAS1149D0563J	5002275	8	1,420	0	0

Part Specifications

Specifications could not be found.

Plex 11/3/17 2:53 PM dart.lacelle.linda



Dart Hawkesbury
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Hawkesbury, ON
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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/27/17	0.00	0.00	Start up container	5d
100	DC	1 pcs	10/27/17	0.00	0.00	DC	
110	Packaging	1 pcs	10/27/17	0.00	0.00	Packaging1	
120	QC	1 pcs	10/27/17	0.00	0.00	QC4	SmB
130	Packaging	1 pcs	10/27/17	0.00	0.00	Packaging3	DAS
140	QC21	1 Ea	10/27/17	0.00	0.00	QC21	21 9-85 NOV 06 2017

Part Op 140 - Photocopy bluefile and create labels per PPP D206-642-312 CHG008

Descriptions: 120 - Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: _____

Job Allocations

Component Part	Required	Inventory	Allocated	Std Qty
✓ AN3-41A 5003523	8	20	0	0
✓ AN4-6A 5003521	12	751	0	0
✓ AN4C5A 5003514	1	38	0	0
✓ AN5-10A 5003512	4	29	0	0
✓ AN5-11A 5004448	8	66	0	0
✓ AN5-12A 5005052	4	56	0	0
D206-642-341BL 5004206	1	0	0	0
✓ D206-648-013BL 5005052	1	0	0	0
✓ D2652 5003511	16	744	0	0
✓ D2712 5003508	10	253	0	0
✓ D2932-2BL 5004082	1	8	0	0
✓ D2933-2BL 5004083	1	10	0	0
✓ D2934 5003504	2	57	0	0
✓ D2935 5003503	2	48	0	0
✓ D2938-2BL 5004085	1	8	0	0
✓ D2939-2BL 5004086	1	8	0	0
✓ D3407-043 5003501	1	44	0	0
✓ D3413-1 5004447	1	36	0	0
✓ D3456-1 5003499	1	40	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

✓ D3457-1 5003497	2	14	0	0
✓ MS21042L3 5002282	8	462	0	0
✓ MS21042L4 5002281	12	1,089	0	0
✓ MS21043-4 5002279	1	797	0	0
✓ NAS1149C0463R 5002278	1	160	0	0
✓ NAS1149D0063J 5002277	8	955	0	0
✓ NAS1149D0463J 5002276	24	1,118	0	0
5002283XY ✓ NAS1149D0563J 5002275	8 XY	846	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q

Date: 13.08.12